Work Ord April-11-13 2:		672				*90	9672) *		· · · · · · · · · · · · · · · · · · ·		·	· , ,	Page 1	
tem ID: Revision ID:	D3901-1				A	ccept	*	1900	040	100)* s	etup Start Stop	i Vi	S1* -	
tem Name: Start Date: Required Date Reference:	Bar -4/09/13 : 4/11/13	Start Qt Req'd Q	•		*6* *6*		·	Cust Item I	ID:	 	·		IV.	S2*	
Approvals:	Process Pla	ın:M_\	_5	Date:\] Date:	3-04-12	Tooling: SPC (Y/N):			ate:		R	tun Start Stop	!/	R1* R2* [/]	
Sequence ID/ Work Center I	D	Operatio Descripti			· :	Set Up/ Run Hou	rs	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. ~ Stamp	_
Draw Nbr D3901	Rev	vision Nbr			· · · · · · · · · · · · · · · · · · ·		. :	11		<u> </u>					
*100 *100* Cold Saw Hyd Mech)),	Memo Cut blanks	nt 55.1875"	*	0.00	. •	Š				73	.05	-22(` _
110 * 11∩ * нааѕі			Мето			0.00	1 3.a	13/05/2	24	÷	<u></u> 6	4		08 08 2.8	
HAAS CNC vertica	al machine #1		I-Mill as pe FOLIO REV DWG REV	/: <u> </u>) & dwg D3901,										

2-Deburr as required

NCR: Ye	es / No				WORK ORDER NON-	COI	NFORM	AANCE / UPDATE		QA Closed:	Dat	te:	
Work Order					DISPOSITION	· ·		AGAIN	IST DE	PARTMENT		_a walk	
	Part No				Rework Skid-tube Crosstube Machining Small Fab Use-as-is Work Order Update Large Fab Composite				ab ing	1	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	Initial nief Eng	Action Description		Sign & Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				÷	•		LT CATE	CORV					
Landing	a Goor				General	AUI	LICATE	JORT					
Landing	g Gear Bending Centre N Cracks Crushed/ Cuffs Heat Tre Inspection Ripples in	'Crimped at on Strip in)/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Te W W	essure/Forced emperature/Cure feld frong Stock Pulled ther
			Extrusion		Drawing		4	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde April-11-13 2:3	The state of the s	0672			Page 2						
Item ID: Revision ID:	D3901-1		· ·	Accept	*N90	0040	100*	s Se	etup Start	171.	S1*
Item Name: Start Date: Required Date:	Bar 4/09/13 4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Ite				5.00p	*NS	らン
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:		R	un Start	"INF	
Sequence ID/ Work Center II	D	Operation Description QC2- Inspect parts off n	nachine FAI/FAIR	Set Up/ Run Hours	Tool I	D Tool#		ccept Ity	Reject Qty		Insp. Stamp
120 QC Quality Control		Memo	MATERIAL WILL BE CU	0.00		13/05/2	1	6	<u>\$</u> _		08
130 *130* QC Quality Control		QC8- Inspect parts - sec Memo ***EXTRA	ond check MATERIAL WILL BE CU	0.00 0.00 T ON ASSEMBLY*	<i>J</i> J 13-0	05-24		6	_Ø_		
¹⁴⁰ *1 ⊿∩ *		Identify as per dwg & St	tock Location: <u>WAC</u> OI	0.00			×	6	/3	-05-27	1 MAI

0.00

Memo

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Packaging

Packaging

NCR: Y	· ·											
					· · · · · · · · · · · · · · · · · · ·			eter-		QA Closed:	Da	te:
					DISPOSITION	ł			AGAINST D	EPARTMENT,	PROCESS	
Work Orde	er:				Downsk	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Dowt N	اما				Rework Scrap	1			Small Fab	Prod. Eng. Coor		Quality
Part N					Use-as-is	┨ ┠	Thermoforming Finishing			-1	e/Packaging	├I '
NCR N	lo.				Work Order Update			Large Fab	Composite	1 1100/3101	Supplier	
NCN					Work Order Opdate	<u>ا</u> ا		Edige (do	composite		Supplier	
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &	<u> </u>	
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificatio	n QC Inspector
Doc/Data												
Equip/Tooling												
Operator [
Material												
Setup		[
Other												
Process							•					
Supplier												
Training												
Unapproved		<u> </u>										
						AUL	T CATE	GORY			 	
Landin	ng Gear				General	F				7		
-	Bending			_	Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
ļ	Centre No	ot Concer	ntric to C)/S	BOM/Route	\vdash	Hardwa		 	Over/Under		Temperature/Cure
}	Cracks				Broken/Damaged	-	,	on Incomplete	,, , <u> </u>	Part Incorre		Weld
}	Crushed/	Crimped.		ļ	Burrs	-		ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
}	Cuffs				Contamination	-	Mainte		<u> </u>	Part Moved	.,	
}	Heat Trea				Countersink	\vdash	Mislabe		 	Positioned \	•	
}	Inspectio		Tube		Cut Too Short	-	Misread	t .	L	Power Loss/	Surge	Other
1	Ripples ir				Drill Holes	\vdash	Offset					
I	Torque Waves in Extrusion		l	Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		0672		*996	\$72*		,	Page 3	
Item ID: Revision ID: Item Name:	D3901-1 Bar			Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date:	4/09/13 4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:				
Reference:			<u> </u>			· .	Run	Start	41544
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		Kun	Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	w to to p.	Set Up/ Run Hours	Tool ID Tool #	Plan Acc Code Qty		•	Reject Insp. Number Stamp

0.00

Memo

150

Quality Control

13/5/27 45

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:													
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
						Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	Ń٥.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality
					•	Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No					Work Order Update	_		Large Fab	Composite]	Supplier	
Root					Descri	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш												
Operator	Ш								}				
Material	Ш												
Setup													
Other							-						
Process	_						ļ						
Supplier													
Training	_	ļ											
Unapproved	Ш.							T CATE	CORY				
Landii	na Go	ar .			··········	General	AUL	T CATE	GURY				
2011011		ending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		. —	t Concer	ntric to C)/S	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	_	acks			·	Broken/Damaged		1	ion Incomplete	 	Part Incorre		Weld
	⊢		Crimped,			Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi		Wrong Stock Pulled
=	_	uffs				Contamination	-	Mainte		<u> </u>	Part Moved	· _	_ ~
	Н	eat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	
	${f oxed{H}}$		Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
	_	pples in				Drill Holes		Offset		<u> </u>			
	To	orque W	aves in E	xtrusion		Drawing		Out of (Calibration				
	Ti	urning Se	equence			Finish		Out of 9	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Picklist Print

April-11-13 2:39:59 PM

Work Order ID:

99672

Parent Item:

D3901-1

Parent Item Name:

Bar

Start Date: 4/09/13

Required Date: 4/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC verified by:JLM

IPP RevB: Now on cnc JFS 12/02/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	254.3470	4.513	28.503158		<u> </u>	
304 BAR .250 x .500				Location		Loc Qty	<u>Lo</u>	c Code	GALLET CAMPAGE OF THE STATE OF	27	13	55 5	12
				MAT049	902	254.347 31.492			19	5.5			
					518	222.855							

										DQA:	Date	
NCR: Y	es / No)			WORK ORDER NON-C	CONFO	ORIV	1ANCE / UPE	DATE	QA Closed:	Date:	
Work Orde	or·	, d. a" ."'			DISPOSITION				AGAINST D	EPARTMENT,		And the second s
Part N	lo				Rework Scrap Use-as-is] Th	N nerm	Skid-tube Aachining oforming	Crosstube Small Fab Finishing	Rec/Sto	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update	J	l	_arge Fab	Composite		Supplier	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initia Chief I		Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
				· L	F	AULT C	ATEG	ORY			1	
Landir	Cracks Crushe Cuffs Heat Tr	Not Conce d/Crimped eat ion Strip ii	J . :	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Inst Inst Ma Mis	rdwar pectic tructio ainter slabel sread	on Incomplete ons Incomplete/U nance	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Ripples in Bend				Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

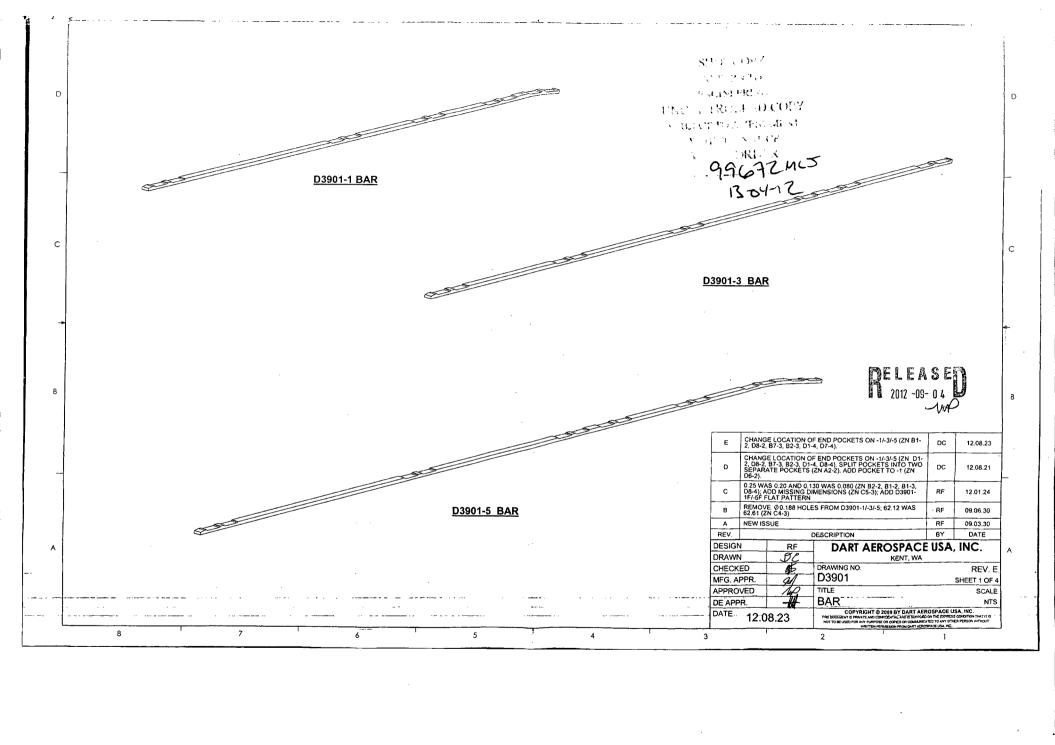
DART AEROSPACE LTD	Work Order:	99672
Description: Bar	Part Number:	D3901-1
Inspection Dwg: D3901 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25 Ref	+/-0.030	0.250	/		Veca	6A-01
4.00	+/-0.030	4.010			11	ıį.
24.00	+/-0.030	24.00	1		Tape	6A-12
35.00	+/-0.030	35.00			41	11
44.51	+/-0.030	44.51			1(/1
50.04	+/-0.100	50.04	/		1(. 4
0.18	+/-0.030	0.175	/		Vern	6A-01
0.50 Ref	+/-0.030	0.496	-		1	h
0.75	+/-0.030	0.740			11	4
0.50	+/-0.030	0.500	~		1,	l)
1.75	+/-0.030	1.760	~		11	۱,
0.50	+/-0.030	0.500	~		Ŋ	1/
,						

			00		
Measured by:	D. P DAS	Audited by:	St	Preliminary Approval:	
Date:	13/05/24/2-89	Date:	13-05-24	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.09.15	New Issue	KJ	
В	12.07.31	Dimensions updated per Dwg Rev C	KJ. , o	2/
С	12.09.26	Dimensions updated per Dwg Rev E	KJ 95	1/1/
			17)	



NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH PER ASTM A276 OR ASTM A240 REF. DART SPEC. M304B0.250X0.500 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE 5 3

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BAR DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.

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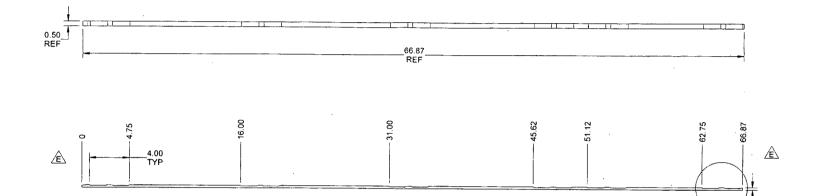
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D3901-3 BAR



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NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH							DESIGN	DART AEROSPACE US		SPACE USA, INC.	Α
PER ASTM 4276 OR ASTM 4240							DRAWN .	DC	KENT, WA		^
REF. DART SPEC. M304B0.250X0.500							CHECKED	as	DRAWING NO.	REV. E	
2) FINISH: NONE							MFG. APPR.	all	D3901	SHEET 3 OF 4	
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED							APPROVED	149	TITLE	SCALE	
5) BREAK SHARP EDGES: (0:005 TO 0.010 MAX						DE APPR.	-#	BAR	NTS	
6) IDENTIFICATION: NONE 7)-WEIGHT-2-21 lbs-							DATE 12.08.23				
R	7	4	,				·		- WALLER POWERS	AN HEAL DIRT REPORT HE VOIC TO	

